

Thursday, 9/14/2006 1:08:28 PM

Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 28599
 Estimate Number : 10733
 P.O. Number : N/A
 This Issue : 9/14/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL / MED FAB
 Previous Run : 28440
 Written By :
 Checked & Approved By :
 Comment : Est A 01.08/27 New Issue SM

Drawing Name : LUG BRACKET

Part Number : D30461

Drawing Number : D3046 REV A

Project Number : N/A

Drawing Revision : A

Material :

Due Date : 9/25/2006

Qty: 14 Um: Each

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0 M1010S12GA

1010/1025/A21/6aA SHEET

Comment: Qty.: 0.1260 sf(s)/Unit Total : 0.7560 sf(s)

1010/1025/A21/6aA SHEET

Batch: M101094

2.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3046

Dwg Rev: AProg Rev: A

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE

Comment: NC BRAKE

Tumble & deburr

Bend as per dwg D3046

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/09/20
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 9/14/2006 1:08:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 28599

Part Number: D30461

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



06-09-25



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.M. 06-09-25

(14)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/09/25

14

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SB 06/09/25

14

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

SB 06/09/26

Job Completion



06-09-26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

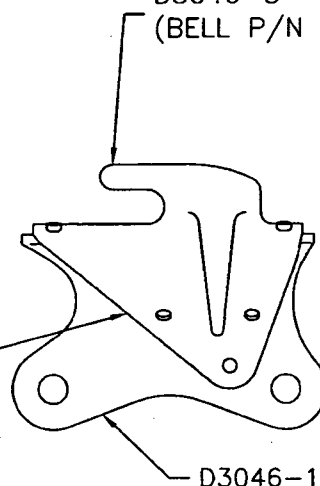
NOTE: Date & initial all entries

DART



| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | REV. A |
|----------------------------|-----------------------------|---------------------------------------------------|--------------|
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3046 | SHEET 1 OF 2 |
| DATE 01.08.23 | TITLE LUG BRACKET | SCALE 1:2 | |
| A | 01.08.23 | NEW ISSUE | |

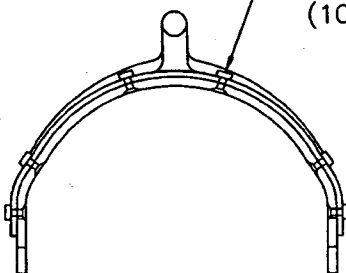
D3046-3
(BELL P/N 206-052-106-1)



D3046-1

CENTER D3046-3
ON D3046-1

TRANSFER DRILL $\varnothing 0.156$ HOLES
FROM D3046-3 TO D3046-1.
C'SINK $\varnothing 0.286 \times 100'$
D3046-1 INSIDE BORE.
ASSEMBLE USING MS20426AD5-7
RIVETS.
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
RE-POWDER AFTER ASSEMBLY.
- 2) REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
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ENGINEERING
RETURN TO
SHOP COPY

UNDER REVIEW

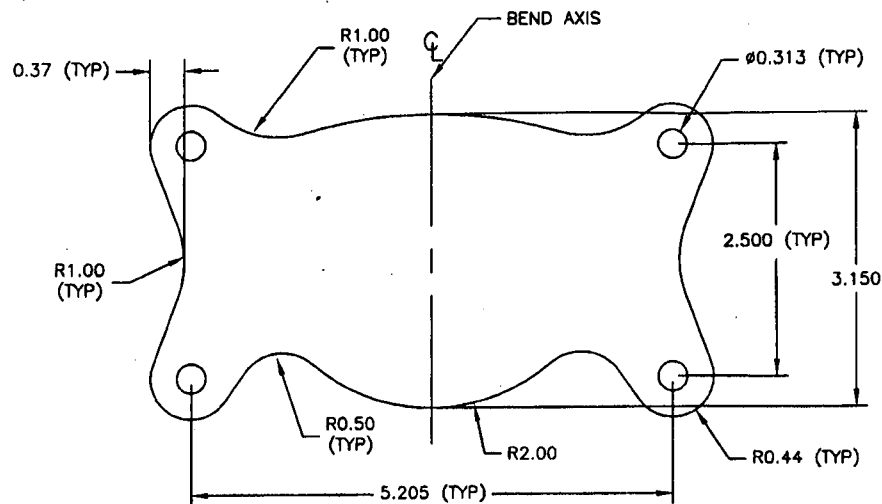
06.06.22-28
CHANGING TO CONTROL
D3046

06.09.14

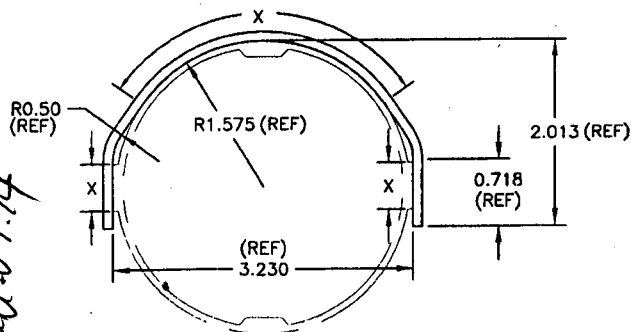
RELEASED
01.08.23

DART

| | | | |
|------------------|----------------|---------------------------------------------------|------------------------|
| DESIGN # | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3046 | REV. A SHEET 2 OF 2 |
| DATE 01.08.23 | | TITLE LUG BRACKET | SCALE 1:2 |



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (C)



D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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01.08.23

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